

Monday, 4/23/2007 3:41:31 PM

Kim Johnston

Process Sheet

Customer

: CU-DAR001 Dart Helicopters Services

Job Number

: 32015

Estimate Number

: 10822

P.O. Number

This Issue

:N/A

: 4/23/2007 Prsht Rev.

: 30875

S.O. No. : NA

Type

: MACHINED PARTS

Drawing Revision Material

Due Date

Drawing Name

Part Number

Drawing Number

Project Number

: N/A

D2274 REV F

: D2274

: RADIUS BLOCK

: NIA : 6/5/2007

Qty:

500 Um: Each

Written By Checked & Approved By

First Issue

Previous Run

Comment

: Est. H 00:05.18

Added inspection level 8

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

6061-T6 Bar .75" x .125"

1.0

M6061T6B0750X00125

0.0962 f(s)/Unit

Total: 48.0900 f(s)

6061-T6 Bar .75" x .125"

BG 07.06.13

Material: 6061-T6 (QQ-A-250/11) or 5052-H34 (QQ-A-250/8) 1/8" X 3/4" BarBatch _iou 775

2.0

SHEAR

HAAS1

SHEAR

Comment: SHEAR

Comment: Qty.:

Shear blanks 9.00" long +/- 0.030" Note: 1 blank makes 9 pieces

HAAS CNC VERTICAL MACHINING #1

3.0



Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per folio D2274

INSPECT PARTS AS THEY COME OFF MACHINE

568

4.0

QC2



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

568

5.0

QC8

SECOND CHECK

Comment: SECOND CHECK

6.0

SMALL & MEDIUM FAB RESOUR

SMÀLÈ FAB 1

Comment: SMALL & MEDIUM FAB RESOURCE 1

Tumble

Deburr any rough edges after tumbling

Dart Aerospace Ltd

W/O:		WORK ORDER CHA	WORK ORDER CHANGES				***************************************
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
				-			
		•					
			·				
							L

Part No: _	P	'AR #:	Fault Category:	~	t	NCR: Yes No	DQA: 1	Date: _	07/06/2
						QA: N/C C	losed:	Date:	

NCR:			WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC		Corrective Action Section B		Verification	Annaval	Approval QC Inspector			
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng				
						2					
		•	•	•		,					
					, a						
		, ,									

NOTE: Date & initial all entries

Date: Monday, 4/23/2007 3:41:31 PM Usery Kim Johnston **Process Sheet** Drawing Name: RADIUS BLOCK Customer: CU-DAR001 Dart Helicopters Services Job Number: 32015 Part Number: D2274 Job Number: Seq. #: Description: Machine Or Operation: HAND FINISHING1 7.0 HAND FINISHING RESOURCE #1 Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1 INSPECT POWDER COAT/CHEMICAL CONVERSION 8.0 QC3 POWDER COAT/CHEMICAL CONVERSION 9.0 PACKAGING 1 PACKAGING RESOURCE #1 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: 10.0 QC21 Comment: FINAL INSPECTION/W/O RELEASE Job Completion C/07/06/20

Dart Ae	rospac	e Ltd -	-	/		_		–	
W/O:			W	ORK ORDER CHANGE	S				
DATE	STEP	STEP PROCED		EDURE CHANGE			Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
			·			, <u> </u>			
Part No	·	PAR #:	Fault Cate	egory:	NCR: Yes	No DQA	\ :	Date: _	
					QA: N/	C Closed	i:	Date:	
NCR:		V	WORK ORD	ER NON-CONFORMAN	ICE (NCR)			
		Description of NC	Description of NC Corrective Action			Section B Verific			Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Section C			Approval Chief Eng	QC Inspector
l									
							1		

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	32015
/ / / STATE		
Description: Radius Block	Part Number:	D2274
Inspection Dwg: D2274 Rev: F		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X	First Article		Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.257	+0.005 -0.000	758				
0.750	+/-0.010	.750				
0.375	+/-0.010	-375	V			
0.125	+/-0.010	.125	\ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \			
0.750	+/-0.010	. 750	/			
0.063	+/-0.010	.063	/			
		_				
		,				
·						
		•				

Measured by:	Audited by:	Prototype Approval:	
Date: 67-26.13	Date: 7/0//2	Date:	

Rev	Date	Change	Revised by	Approved
Α	03.10.07	New Issue	KJ/RF	

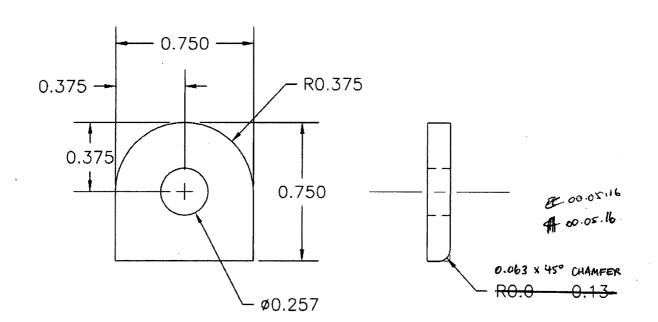






	DESIG	KE	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
	CHEC	ON AY	APPROVED	DRAWING NO. REV. F
١	1	W	173	D2274 SHEET 1 OF 1
	DATE		•	TITLE SCALE
	98.0	8.11		RADIUS BLOCK 2:1
	Α		94.09.29	NEW ISSUE
	С		95.07.12	RADIUS ENDS
	D		97.03.24	ADD MATERIAL SPECIFICATION
	Ε		97.12.12	ADD FINISH & TOLERANCE QSI
	F		98.08.11	RO.0 - 0.13 WAS RO.063 - 0.125

RELEASED 18/08/18 KE



SHOP COPY RETURN TO ENGINEERING JNCONTROLLED COPY SUBJECT TO AMENDMENT

WITHOUT NOTICE

MATERIAL: 5052-H34 (QQ-A-250/8) 0.125 THICK OR 6061-T6 (QQ-A-250/11) 0.125 THICK

FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 NO 3201

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

